

Work Order ID 116981

April-24-14 8:48:45 AM

116981

Page 1

Item ID: D205-641-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: GHW/ Mod

Start Date: 4/23/14 Start Qty: 4.00

4

Cust Item ID:

Required Date: 4/23/14 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MCS Date: 140428

Tooling:

Date:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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DSI 9536	A
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100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy D205-641 bluefile & type labels per PPP D205-641-011 CHG002

DAS
06
9-89

MAY 16 2014 4

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

4

DAS
33
9-89
1405-14

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

DAS
06
9-89

MAY 16 2014 4

DAS
28
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 116981

April-24-14 8:48:45 AM

116981

Page 2

Item ID: D205-641-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: GHW/ Mod

Start Date: 4/23/14 Start Qty: 4.00 ***4***

Cust Item ID:

Required Date: 4/23/14 Req'd Qty: 4.00 ***4***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

130

Packaging

Packaging

0.00

0.00

Memo

Identify and pack for shipping as per PPP D205-641-011

Location: 125

DAS

06

9-89

MAY 16 2014

140

140

QC

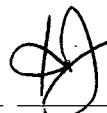
QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

14/5/20 

mf

14-5-16

DQA: _____ Date: _____



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Transport									
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FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

April-24-14 8:48:48 AM

Page 1

Work Order ID: 116981

116981

Parent Item: D205-641-011

D205-641-011

Parent Item Name: GHW/ Mod



Start Date: 4/23/14

Required Date: 4/23/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:J Removed Manufacturing 05-10-25 JLM
IPP K Rev D dwg 09.01.28 EC verifiedby:DD IPP REV:L
10.12.08 PER ECN10-661 DSI9536 REVA DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4C46A		Purchased	No			110	Each	222.0000		16			
<div><div>*AN4C46A*</div><div>Bolt</div><div>DAS 06 9-89</div></div>													
<div><div><u>Location</u></div><div><u>Loc Qty</u></div><div><u>Loc Code</u></div></div>													
<div><div>ST</div><div>2</div><div></div></div>													
<div><div>123642</div><div>2</div><div></div></div>													
<div><div>ST359</div><div>20</div><div></div></div>													
<div><div>m127953</div><div>20</div><div></div></div>													
<div><div>ST517a</div><div>200</div><div></div></div>													
<div><div>m128227</div><div>200</div><div></div></div>													
<div><div>128227</div><div></div><div></div></div>													
D2570		Manufactured	No			110	Each	341.0000		32			
<div><div>*D2570*</div><div>Bushing</div><div>DAS 06 9-89</div></div>													
<div><div><u>Location</u></div><div><u>Loc Qty</u></div><div><u>Loc Code</u></div></div>													
<div><div>FG</div><div>12</div><div></div></div>													
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DQA: _____ Date: _____



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Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
--	--	---	--

Picklist Print

April-24-14 8:48:48 AM

Page 2

Work Order ID: 116981

116981

Parent Item: D205-641-011

D205-641-011

Parent Item Name: GHW/ Mod

Start Date: 4/23/14

Required Date: 4/23/14

Start Qty: 4.00

Required Qty: 4.00

D3405-043

Manufactured No

110

Each

22.0000

4

~~*D3405-043*~~
Gh Lug

** 2x 116660

DAS
33
9-89

DAS
06
9-89

Location

Loc Qty

Loc Code

ST461

16

107261

16

ST468

6

108792

1

110178

5

2x 107261

DAS
28
9-89

MS21042L4

Purchased No

110

Each

8,383.000

4

16

~~*MS21042L4*~~
Locknut

**

DAS
33
9-89 14-05-14

DAS
10
9-89

NIA

Location

Loc Qty

Loc Code

ST314

56

105054

12

m126015

12

m126275

32

ST509

8316

m127255

71

m127813

1083

m128300

2162

m128798

5000

ST518

11

m127376

11

128300

DAS
28
9-89

DAS
10
9-89

DAS
06
9-89

~~MS21042L4~~

~~m127255~~

14

M.H.

DAS
28
9-89

April-24-14 8:48:48 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube <input type="checkbox"/></td> <td style="width:15%;">Crosstube <input type="checkbox"/></td> <td style="width:15%;">Water Jet <input type="checkbox"/></td> <td style="width:15%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D205-634 REV. F AND
INSTALLATION INSTRUCTIONS D204-635 REV. F

REF. TCCA STC SH96-88
REF. FAA STC SR00563NY
REF. EASA STC EASA.IM.R.S.01303

12-64-11
11-64-11

PURPOSE:

THE PARTS LIST OF INSTALLATION INSTRUCTIONS D205-634 REV. F AND D204-635 REV. F LISTS THE INCORRECT PART NUMBER FOR THE BOLT PROVIDED WITH D205-641-011 GROUND HANDLING KIT. THE CORRECT PART NUMBER FOR THE BOLT IS AN4C46A.

CHANGE:

THE PART NUMBER IN SECTION 5.0 OF D205-634 REV. F AND D204-635 REV. F AND SECTION 32.9 OF ICA-D204-635 REV. 3 IS AMENDED AS FOLLOWS:

5.0 PARTS LIST (D205-634 REV. F)

Item	634 -011	634 -015	634 -041	634 -045	641 -011	PART NUMBER	DESCRIPTION
	X					D205-634-011	SKIDTUBE INSTALLATION (STANDARD)
		X				D205-634-015	SKIDTUBE INSTALLATION (MODIFIED)
	1		X			D205-634-041	SKIDTUBE
		1		X		D205-634-045	SKIDTUBE
	1	1			X	D205-641-011	GROUND HANDLING KIT

IS:

52					4	AN4C46A	BOLT
----	--	--	--	--	---	---------	------

WAS:

52					4	AN4C47A	BOLT
----	--	--	--	--	---	---------	------

5.0 PARTS LIST (D204-635 REV. F)

32.9 PARTS LIST (ICA-D204-635 REV. 3)

Item	635 -011	635 -041	641 -011	PART NUMBER	DESCRIPTION
	X			D204-635-011	SKIDTUBE INSTALLATION
	1	X		D204-635-041	SKIDTUBE
	1		X	D205-641-011	GROUND HANDLING KIT

IS:

52			4	AN4C46A	BOLT
----	--	--	---	---------	------

WAS:

52			4	AN4C47A	BOLT
----	--	--	---	---------	------

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: [Signature]
D. SHEPHERD (DE # 02)

DATE: 10.11.26
CERT. NO.: SH96-88
ISSUE NO.: 3

A	NEW ISSUE (REF. CAR10-27)	MB	10.11.26
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		DSI 9536	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		P/N CORRECTION	NTS
DATE	10.11.26	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

MAY 16 2014

DART AEROSPACE LTD.

REFERENCE ONLY

DAS
06
9-89

D205-634

Page 11 of 13

5.0 PARTS LIST

Item	634 -011	634 -015	634 -041	634 -045	641 -011	Part Number	Description
	X					D205-634-011	SKIDTUBE INSTALLATION (STANDARD)
		X				D205-634-015	SKIDTUBE INSTALLATION (MODIFIED)
	1		X			D205-634-041	SKIDTUBE
		1		X		D205-634-045	SKIDTUBE
	1	1			X	D205-641-011	GROUND HANDLING KIT
1			1			D2580-041	205 SKIDTUBE ASSEMBLY (STANDARD)
1				1		D2580-045	205 SKIDTUBE ASSEMBLY (MODIFIED)
2A			16	16		D2594-1	* PLUG
2B			16	16		D2594-3	* O-RING
3			1	1		D2855	* AFT CAP
4			2	2		AN3-5A	* BOLT
5			2	2		NAS1149D0332J	* WASHER (AN960JD10L)
6A			1	1		D3564-9	* WEARSHOE (REPLACES D2577-1)
6B			1	1		D3566-1	* GASKET
7A			1	1		D3564-11	* WEARSHOE (REPLACES D2577-3)
7B			1	1		D3566-1	* GASKET
8A			1	1		D3564-5	* WEARSHOE (REPLACES D2577-5)
8B			1	1		D3566-5	* GASKET
9A			1	1		D3564-13	* WEARSHOE
9B			1	1		D3566-13	* GASKET
10			50	50		AN3C4A	* BOLT (REPLACES AN3-4A)
11			50	50		NAS1149C0332R	* WASHER (AN960C10L)
12			50	50		ALS4-1032-130	* INSERT
13			2	2		ALS4-1032-225	* INSERT
20	1	1				D2571	SADDLE, FWD OUTSIDE
21	1	1				D2572	SADDLE, FWD INSIDE
22	1	1				D2573	SADDLE, AFT OUTSIDE
23	1	1				D2574	SADDLE, AFT INSIDE
24	8	8				AN4-51A	BOLT
25	16	16				D2570	BUSHINGS
26	8	8				MS21042L4	NUT (OR MS21042-4)
27	8	8				AN6-12A	BOLT
28	8	8				NAS1149D0668J	WASHER (AN960JD616)
29	16	16				AN4-6A	BOLT
30	32	32				NAS1149D0463J	WASHER (AN960JD416)
31	16	16				MS21042L4	NUT (OR MS21042-4)
32	4	4				D2747	SET SCREW
33	2	2				D3533-1	SET SCREW
40	1	1				D3407-041	TOW RING (REPLACES D2968-041)
41	1	1				D3456-1	WASHER
43	1	1				MS21043-4	NUT
44	2	2				D3417-5	WASHER
50					X	D3405-041	LUG ASSEMBLY (REPLACES D2736-1)
51					X	D3405-043	LUG ASSEMBLY (REPLACES D2736-3)
52					4	AN4G46A	BOLT
53					8	D2570	BUSHING
54					4	MS21043-4	NUT (OR MS21042-4)
60	2	2				D2876	SADDLE SPACER
61	2	2				D2877	SADDLE SPACER

*DENOTES THAT PART IS INCLUDED WITH D2580-041/-045 ASSEMBLY ABOVE

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Revision: H
 Date: 14.04.11

Work Order ID 116981

116981

April-24-14 8:48:45 AM

Item ID: D205-641-011

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Revision ID:

Item Name: GHW/ Mod

Start Date: 4/23/14 Start Qty: 4.00

4

Cust Item ID:

Required Date: 4/23/14 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: Process Plan: MLJ Date: 140428 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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DSI 9536	A
----------	---

100

Document Control
DOCUMENT CONTROL

0.00

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy D205-641 bluefile & type labels per PPP D205-641-011 CHG002

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

MLJ 1405-14

(4)